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“Step Out From the Old to the New”

IS 1095 (1991): Handloom cotton dress materials, bleached, dyed, printed, striped or checked [TXD 8: Handloom and Khadi]

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“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartṛhari—Nītiśatakam

“Knowledge is such a treasure which cannot be stolen”



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IS 1095 : 1991

(Superseding IS 861 : 1983, IS 1098 : 1957,
IS 1240 : 1958 and IS 1556 : 1960)

भारतीय मानक

**हथकरघा निर्मित सूती परिधान सामग्री, विरंजित, रंजित,
छापेदार, धारीदार अथवा चौखानेदार**

(पहला पुनरीक्षण)

Indian Standard

**HANDLOOM COTTON DRESS MATERIAL,
BLEACHED, DYED, PRINTED, STRIPED
OR CHECKED**

(*First Revision*)

UDC 677·21·074 : 687·1

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BUREAU OF INDIAN STANDARDS
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NEW DELHI 110002

FOREWORD

This Indian Standard (First Revision) was adopted by the Bureau of Indian Standards, after the draft finalized by the Handloom and Khadi Sectional Committee had been approved by the Textile Division Council.

This standard was first issued in 1957. It has now been revised in order to overcome certain difficulties encountered by the handloom industry in its implementation. Following are the important changes carried out while revising this standard:

- a) Keeping in view the end use of the material, the following Indian Standards have been amalgamated with this standard :
 - 861 : 1983 Handloom cotton jaconet cloth, grey, dressed (*first revision*)
 - 1098 : 1957 Handloom cotton cambric, bleached
 - 1240 : 1958 Handloom cotton nainsook, bleached or dyed
 - 1556 : 1960 Handloom cotton poplin, bleached or dyed
- b) Use of cotton yarn conforming to IS 171 : 1985 'Cotton and cotton regenerated cellulosic fibre blended grey yarn (*third revision*)' has been specified.
- c) Constructional particulars have been modified taking into consideration the present production patterns prevailing in the handloom industry.
- d) Only negative tolerances have been specified on ends/dm, picks/dm and mass g/m² to ensure minimum desirable construction. There being no tolerance on positive side on these requirements, it would provide flexibility to industry to adjust construction of the fabric depending upon market demands.
- e) Breaking load requirement has been specified as optional requirement. This requirement has to be enforced in case it is not possible to establish that the cotton yarn conforming to IS 171 : 1985 has been used.
- f) Tolerances on length and width have been adopted from the instructions issued by the Central Government under the *Trade and Merchandise Marks Act, 1958* (43 of 1958) as given in *Notification No. S. O. 2937 dated 20 September 1962*.
- g) For determining the conformity of the cloth to the requirements laid down in this standard, a provision has been incorporated to allow testing of specimens in prevailing atmospheric conditions. However, in all cases of disputes, the specimens shall be tested after conditioning in the standard atmospheric conditions.
- h) Provision has been incorporated for agreement between the buyer and the seller with respect to the permissible number of defects in the dress material.

This standard, consequent upon the inclusion of the requirements of handloom cotton jaconet cloth, cambric, nainsook and poplin in it, as mentioned in para 2, item (a) above, supersedes IS 861 : 1983, IS 1098 : 1957, IS 1240 : 1958 and IS 1556 : 1960.

For the purpose of deciding whether a particular requirement of this standard is complied with the final value, observed or calculated, expressing the result of a test or analysis, shall be rounded off in accordance with IS 2 : 1960 'Rules for rounding off numerical values (*revised*)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

Indian Standard

HANDLOOM COTTON DRESS MATERIAL, BLEACHED, DYED, PRINTED, STRIPED OR CHECKED

(First Revision)

1 SCOPE

1.1 This standard prescribes constructional particulars and other requirements for twenty varieties of handloom cotton dress material, bleached, dyed, printed, striped or checked.

1.2 This standard does not specify general appearance, feel, finish, etc, of the cloth.

2 REFERENCES

The Indian Standards listed in Annex A are necessary adjuncts to this standard.

3 ATMOSPHERIC CONDITIONS FOR TESTING

Test specimens may be conditioned and tested in the prevailing atmosphere for determining the conformity of the cloth to this standard. However, in all cases of disputes, the specimens

shall be conditioned and tested in the standard atmosphere as specified in the referred Indian Standards on test methods.

4 YARN

The cotton yarn used shall conform to the requirements specified in IS 171 : 1985.

5 REQUIREMENTS

5.1 The cloth shall be woven in plain weave.

5.2 The cloth shall conform to the requirements specified in Table 1.

5.2.1 However, the breaking load requirement shall be an optional requirement. It shall be enforced only when conformance of cotton yarn to the requirements specified in IS 171 : 1985 is not known.

Table 1 Constructional Particulars and Breaking Load Requirements for Handloom Cotton Dress Material, Bleached, Dyed, Printed, Striped or Checked

(Clause 5.2)

Variety No.	Count of Yarn (Universal Count) (Cotton Count) ¹		Ends/dm (4)	Picks/dm (5)	Mass (6) g/m ²	Breaking Load	
	Warp (2)	Weft (3)				Warpway (7) N	Weftway (8) N
(1)							
1	30 tex (20 s)	30 tex (20 s)	190	170	112	220	200
2	30 tex (20 s)	30 tex (20 s)	168	152	100	200	180
3	23 tex (26 s)	23 tex (26 s)	290	275	132	240	240
4	23 tex (26 s)	23 tex (26 s)	220	200	100	180	170
5	20 tex (30 s)	20 tex (30 s)	380	240	126	260	180
6	20 tex (30 s)	20 tex (30 s)	295	230	110	200	160
7	20 tex (30 s)	20 tex (30 s)	240	220	95	180	160
8	20 tex (30 s)	20 tex (30 s)	190	170	75	150	130
9	20 tex (30 s)	20 tex (30 s)	100	100	42	100	100
10	16 tex (36 s)	16 tex (36 s)	240	220	75	160	140
11	16 tex (36 s)	16 tex (36 s)	100	100	35	80	80
12	15 tex (40 s)	15 tex (40 s)	440	250	105	320	180
13	15 tex (40 s)	15 tex (40 s)	280	270	84	200	200
14	15 tex (40 s)	15 tex (40 s)	220	200	64	160	160
15	10 tex (60 s)	10 tex (60 s)	380	380	78	250	250
16	10 tex (60 s)	10 tex (60 s)	295	285	60	200	190
17	10 tex (60 s)	10 tex (60 s)	280	250	55	190	160
18	7.5 tex (80 s)	7.5 tex (80 s)	320	300	48	170	160
19	7.5 tex (80 s)	7.5 tex (80 s)	290	255	42	150	125
20	6 tex (100 s)	6 tex (100 s)	335	305	41	140	120
Tolerance percent	—	—	—5	—5	—5	—5 on average value and —15 on individual reading	
Method of Test	—			IS 1963 : 1981	IS 1964 : 1970 or Annex B	IS 1969 : 1985	

¹For guidance only.

5.3 The cloth shall also conform to the requirements specified in Table 2.

Table 2 Other Requirements for Handloom Cotton Dress Material, Bleached, Dyed, Printed, Striped or Checked

Sl No	Characteristic	Requirement	Method of Test
(1)	(2)	(3)	(4)
i)	Dimensional change, percent, <i>Max</i>	4	IS 2977 : 1989
ii)	Scouring loss, percent, <i>Max</i>	2.5	IS 1383 : 1977
iii)	pH value of the aqueous extract	6.0 to 8.5	IS 1390 : 1983
iv)	Colour fastness:		
a)	Light	4 or better	IS 686 : 1985 or IS 2454 : 1985
b)	Washing, Test 3:		IS 764 : 1979
1)	Change in colour	4 or better	
2)	Staining on fabric	4 or better	
c)	Bleaching:		IS 762 : 1988
1)	Change in colour	4 or better	
2)	Staining on fabric	4 or better	
d)	Perspiration:		IS 971 : 1983
1)	Change in colour	4 or better	
2)	Staining on fabric	4 or better	

5.4 Dimensions

The length and width of the cloth, when determined in accordance with IS 1954 : 1969, shall be as agreed to between the buyer and the seller or as declared by the seller, subject to the tolerances specified in the *Government of India, Ministry of Commerce and Industry (Trade and Merchandise Marks) Notification No. S.O. 2937 dated 20 September 1962 issued under the Trade and Merchandise Marks Act, 1958 (43 of 1958)* (see Annex C).

5.5 Sealed Sample

If in order to illustrate or specify the indeterminate characteristics, such as general appearance, lustre, feel and shade, a sample has been agreed upon and sealed, the supply shall be in conformity with the sample in such respects.

The custody of the sealed sample shall be a matter of prior agreement between the buyer and the seller.

6 INSPECTION

6.1 The cloth when visually inspected should be free from the major flaws listed in Annex D.

The number of permissible major flaws per unit length shall be as agreed to between the buyer and the seller.

6.2 For details of the flaws mentioned in 6.1, reference may be made to IS 4125 : 1987.

7 MARKING

7.1 The cloth shall be suitably marked with the following information:

- a) Name of the material and variety No.,
- b) Length (m) and width (cm), and
- c) Indication of the source of manufacture.

7.2 The cloth may also be marked with the Standard Mark.

8 PACKING

Unless otherwise agreed upon by the buyer and seller the cloth shall be packed in bales or cases in accordance with the procedure laid down in IS 1347 : 1972 or IS 293 : 1980.

9 SAMPLING

9.1 Lot

The quantity of the cloth of the same variety delivered to one buyer against one despatch note shall constitute a lot.

9.2 The conformity of a lot to the various requirements specified in the standard shall be determined on the basis of tests carried out on the samples selected from it.

9.3 Unless otherwise agreed, the number of pieces to be selected at random for inspection shall be in accordance with Table 3. For random selection of samples, IS 4905 : 1968 may be followed.

Table 3 Sample Size and Permissible Number of Non-conforming Pieces
(Clauses 9.3 and 9.4)

Lot Size	Sample Size	Permissible Number of Non-conforming Pieces	Sub-sample Size
(1)	(2)	(3)	(4)
Up to 25	3	0	2
26 to 50	5	0	2
51 to 150	8	0	3
151 to 300	13	1	3
301 to 500	20	1	5
501 to 1 000	32	2	5
1 001 and above	50	3	8

9.4 Number of Samples and Criteria for Conformity

The number of samples to be drawn and the criteria for conformity of the material for various characteristics shall be as follows :

<i>Characteristics</i>	<i>Number of Samples</i>	<i>Criterion for Conformity</i>
Ends, picks, mass, length, width and visual inspection	According to col 2 of Table 3	Number of non-conforming pieces shall not exceed the corresponding number given in col 3 of Table 3
Dimensional change, scouring loss, pH value, colour fastness and breaking load	According to col 4 of Table 3	All the pieces shall meet the requirement

ANNEX A (Clause 2)

LIST OF REFERRED INDIAN STANDARDS

<i>IS No.</i>	<i>Title</i>	<i>IS No.</i>	<i>Title</i>
171 : 1985	Cotton and cotton regenerated cellulosic fibre blended grey yarn (<i>third revision</i>)	1390 : 1983	Methods for determination of pH value of aqueous extracts of textile materials (<i>first revision</i>)
293 : 1980	Code for seaworthy packaging of cotton yarn and cloth (<i>third revision</i>)	1954 : 1969	Methods for determination of length and width of fabrics (<i>first revision</i>)
686 : 1985	Methods for determination of colour fastness textile materials to daylight (<i>first revision</i>)	1963 : 1981	Methods for determination of threads per unit length in woven fabrics (<i>second revision</i>)
762 : 1988	Method for determination of colour fastness of textile materials to hypochlorite bleaching (<i>first revision</i>)	1964 : 1970	Methods for determination of weight per square metre and weight per linear metre of fabrics (<i>first revision</i>)
764 : 1979	Method for determination of colour fastness of textile materials to washing : Test 3 (<i>second revision</i>)	1969 : 1985	Methods for determination of breaking load and elongation of woven textile fabrics (<i>second revision</i>)
971 : 1983	Method for determination of colour fastness of textile materials to perspiration (<i>first revision</i>)	2454 : 1985	Methods for determination of colour fastness of textile materials to artificial light (xenon lamp) (<i>first revision</i>)
1347 : 1972	Inland packaging of cotton cloth and yarn (<i>first revision</i>)	2977 : 1989	Fabrics (other than wool) — Method for determination of dimensional changes on soaking in water (<i>first revision</i>)
1383 : 1977	Methods for determination of scouring loss in grey and finished cotton textile materials (<i>first revision</i>)	4125 : 1987	Glossary of terms pertaining to defects in fabrics (<i>first revision</i>)
		4905 : 1968	Methods for random sampling

ANNEX B (Table 1)

METHOD FOR DETERMINATION OF MASS OF FABRIC

B-1 Cut four specimens of 100 mm × 100 mm each from a sample. Condition all the specimens in a desiccator charged with saturated solution of sodium nitrate at $27 \pm 2^\circ\text{C}$ for a period of 24 hours. Remove all the specimens from the

desiccator and immediately determine their collective mass in a weighing balance to the nearest milligram.

B-2 Calculate the mass of the fabric in g/m².

ANNEX C
(Clause 5.4)

**EXTRACTS FROM THE GOVERNMENT OF INDIA, MINISTRY OF COMMERCE
AND INDUSTRY (TRADE AND MERCHANDISE MARKS) NOTIFICATION
NO. S.O. 2937 DATED 20 SEPTEMBER 1962**

1. *A trade description of length stamped on grey, bleached mercerized or coloured cotton piece goods:*

- i) In pieces stamped as of length 9 meters and below, the stamped length shall not exceed the actual length by more than 1 percent of the piece length or 7.5 cm, whichever is less; and
- ii) In pieces stamped as of length above 9 metres, the stamped length shall not exceed the actual length by more than 0.6 percent of the piece length or 7.5 cm, whichever is higher.

Provided that the average length of the pieces in question shall not be less than the stamped length.

2. *A trade description of width stamped on grey, bleached, mercerized or coloured cotton piece goods:*

- i) In pieces stamped as of width 102 cm or below, the stamped width shall not exceed the actual width at any point by more than 1.3 cm;
- ii) In pieces stamped as of width over 102 cm up to 152 cm, the stamped width shall not exceed the actual width at any point by more than 1.25 percent of the stamped width of the piece; and
- iii) In pieces stamped as of width 152 cm and above, the stamped width shall not exceed the actual width at any point by more than 1.25 percent of the stamped width of the piece or 2.5 cm, whichever is less.

Provided that the average width of the pieces in question shall not be less than the stamped width.

ANNEX D
(Clause 6.1)

LIST OF MAJOR FLAWS

- 1) One or more ends missing in the body of the material throughout its length, more than three ends missing at a place and running over 60 cm, or prominently noticeable double ends running throughout the piece.
- 2) Undressed snarls noticeable over a length exceeding 5 percent of the length of the piece.
- 3) Smash definitely rupturing the texture of the fabric.
- 4) Hole, cut or tear.
- 5) Reed marks prominently noticeable over a length exceeding 5 percent of the piece.
- 6) Defective or damaged selvedge noticeable over a length exceeding 5 percent of the length of the piece.
- 7) Skewing of more than 3 percent on weft.
- 8) Weft crack or two or more missing picks across the width of the fabric.
- 9) Warp or weft bar due to difference in raw material, count, twist, lustre, colour shade

- or spacing of adjacent groups of yarns (starting mark).
- 10) More than two adjacent ends running parallel, broken or missing and extending beyond 10 cm.
- 11) Noticeable warp or weft float in the body of the fabric.
- 12) Noticeable oil or other stain in the fabric.
- 13) Oily weft in the fabric.
- 14) Prominently noticeable slub.
- 15) Conspicuous broken pattern.
- 16) Gout due to foreign matter, usually lint or waste, woven into the fabric.
- 17) Prominent selvedge defect.
- 18) Significant shading or listing having a gradual change in tone or depth of shade (excluding selvedge).
- 19) Coloured flecks.
- 20) Blurred or dark patch.
- 21) Patchy, streaky or uneven dyeing.
- 22) Dye bar.
- 23) Fuzzy appearance.

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